

Work Order ID 152594

Tuesday, November 01, 2016 12:45:41 PM

152594

Page 1

Item ID: 646.3710

Accept

DAS
13
9-89***N900040100***Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 11/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: NOV 01 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

646.3700

A

110

0.00

110

Purchasing

Memo

0.00

Purchasing

Issue P/O:

34193

Manufacture as per dwg

Possible supplier: SOUTHLAND FABRICATION

Material release note is required.

30

NOV 04 2016

DAS
13
9-89

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.07

Packaging

30x SP16-1216

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

30

DAS
38
9-89

JAN 11 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :																						
Misidentified ☐	☐	Past Due ☐																							

Work Order ID 152594***152594***

Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

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20

Cust Item ID:

Required Date: 11/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Outsource process - Anodize

Memo

Issue P/O to ATG : _____

1- Black Anodize as per Dwg 646.3700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

599.98

*one stop shop
at vendor.*

NOV 04 2016

DAS
13
9-89

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Packaging

Memo

0.07

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Quality Control

Memo

0.07

DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 152594***152594***

Page 3

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Process Plan:

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Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Receive & Inspect for Damage & Mat'l Certs

0.00

190

Packaging

Memo

0.07

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

Packaging

DAS
6
9-89

JAN 17 2017

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.33

Quality Control

17/01/18

MF
17-1-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

Picklist Print

Tuesday, November 01, 2016 12:45:46 PM

Page 1

Work Order ID: 152594

152594

Parent Item: 646.3710

646 3710

Parent Item Name: Doubler

Start Date: 11/3/2016

Required Date: 11/17/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.12.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3710P *646 3710P* Doubler		Purchased	No				Each	0.0000	**	20 30		SP 10-12-16	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

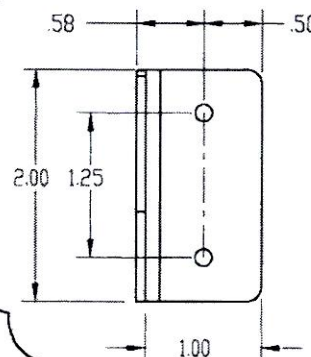
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

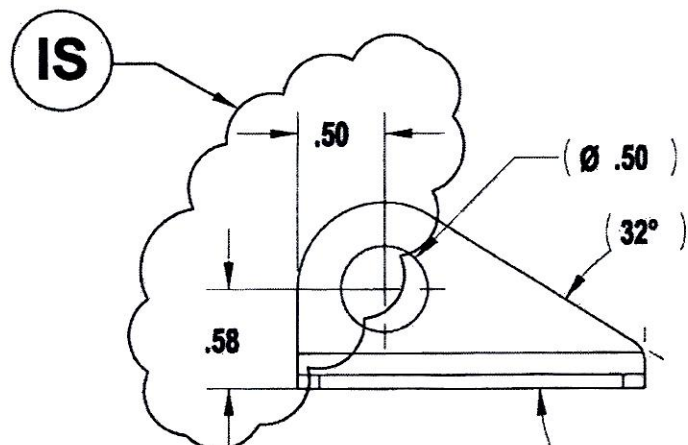
IS



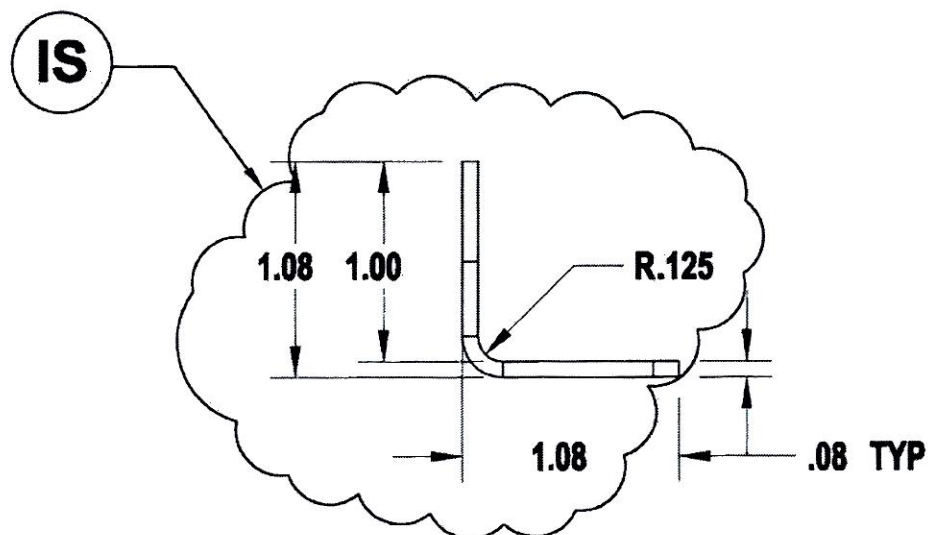
SHEET 7, ZONE B1 IS:

SHOP COPY
RETURN
ENGINEER
UNCONTROL
SUBJECT TO APPROVAL
WITHOUT
WORK ORDER
NO. 152594
MLJ
16-11-01

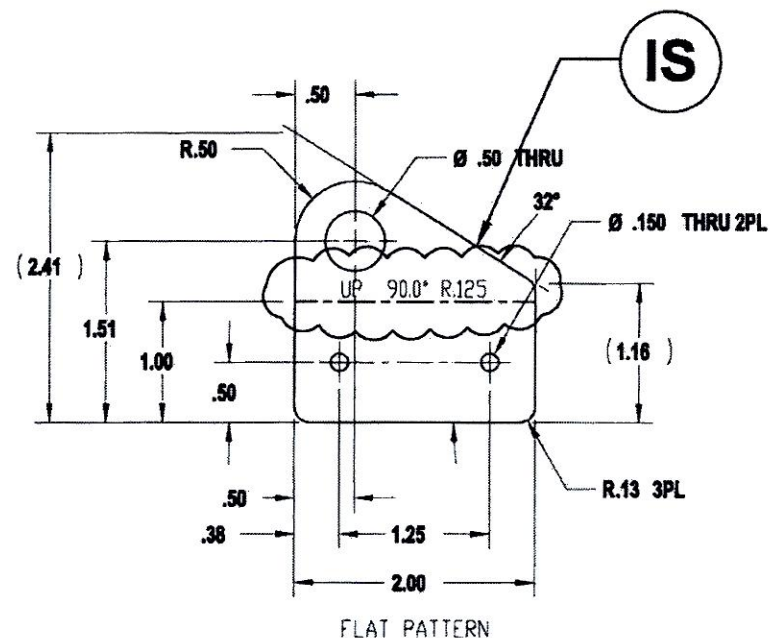
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BDM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

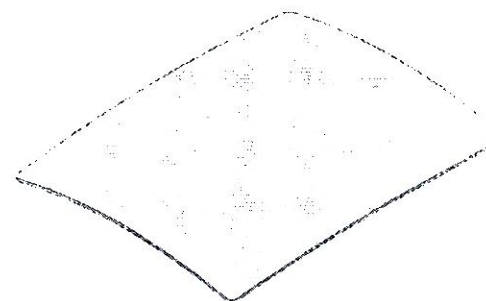
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REV	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 03702		PPC

NOTES:

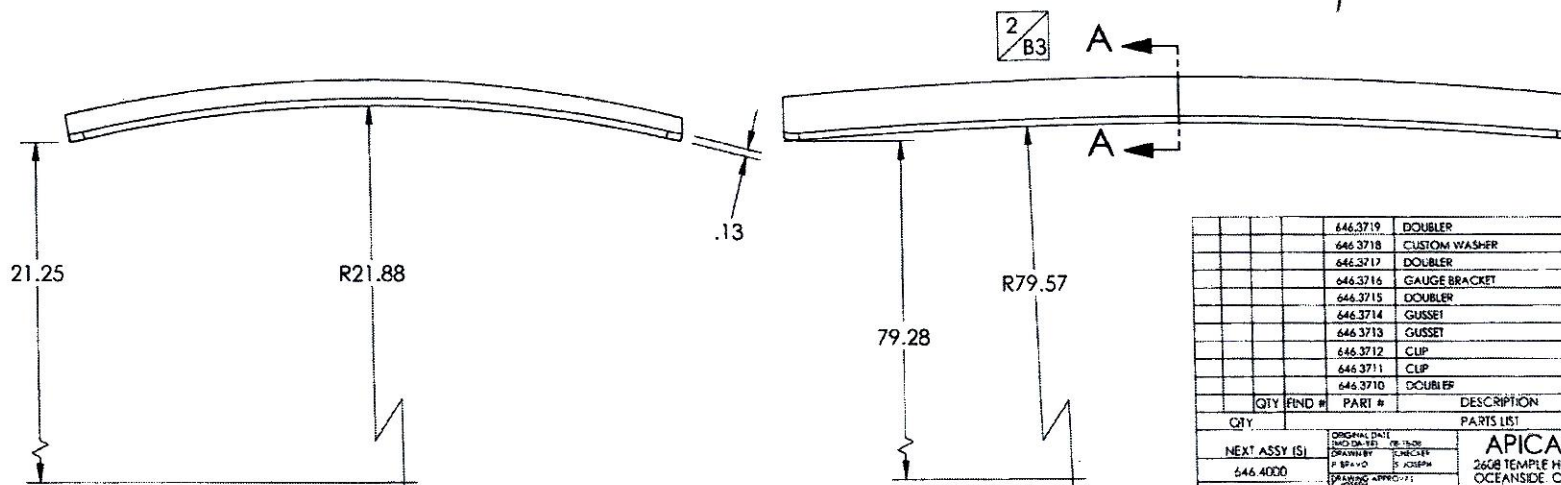
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III.
CLASS 2. COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604. CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

UNINCORPORATED ECN(s)

03702

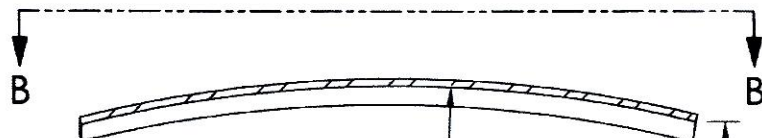


QTY	END #	PART #	DESCRIPTION	MAT'L	SPEC.
		646.3719	DOUBLER		
		646.3718	CUSTOM WASHER		
		646.3717	DOUBLER		
		646.3716	GAUGE BRACKET		
		646.3715	DOUBLER		
		646.3714	GUSSET		
		646.3713	GUSSET		
		646.3712	CLIP		
		646.3711	CLIP		
		646.3710	DOUBLER		

ORIGINAL DATE UNINCORPORATED	DATE 07/15/04
DRAWN BY P. BRAYO	CHECKED BY S. JOSEPH
DESIGNED BY P. BRAYO	APPROVED BY P. BRAYO
DATE 07/15/04	SCALE NONE

NEXT ASSY IS 646.4000		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
SHEETMETAL		SHEETMETAL	
DATE 07/15/04		REV A	
SHEET 1 OF 9		SHEET 1 OF 9	

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R21.94

21.33

SECTION A-A



R395.138

R.13 4PL

13.51

10.49

10.54

SECTION B-B

ORIGINAL DATE 10/04/10 08:18:08	APICAL INDUSTRIES			
DRAWN BY P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
CHECKED BY S. JOSEPH	SHEETMETAL			
DRAWING APPROVAL S. JOSEPH				
SCALE 1:1				
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°				
SCALE: NONE	SHEET	CAGE CODE B 07/02/16	DWG. NO. 646.3700	REV A
	SHEET NAME		SHEET 2 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO34193

Purchase Order Date 11/4/2016 9:33:28 AM
PO Print Date 11/4/2016

Page Number 1 of 2

Order From :
SOUTHLAND FABRICATION
353 INDUSTRIAL WAY
FALLBROOK, CALIFORNIA 92028

VU-SOU004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

NOV 04 2016

Contact Name
Vendor Phone 760-723-4006

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	646.3710P ✓ AS PER DWG 646.3710 REV.A B152594	Doubler ✓	11/28/2016 Yes 11/28/2016		30.00 Each	\$268.00	\$8,040.00
						Line Total:	\$8,040.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	11/28/2016 No 11/28/2016		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A007 first article inspection, (FAI) documentation maintained by supplier A016 personnel qualification A040 notification of escape clauses A041 quality management system A042 dart notification by supplier A043 retention of quality document						

Note:

11/4/2016



PACKING SLIP

No : 00017871

Andlex Inc dba Southland Fabrication
353 Industrial Way Phone 760-723-4006
Fallbrook CA 92028 Fax 760-723-4604

To: Dart Aerospace Ltd
1270 Aberdeen Street

ShipTo: Dart Aerospace Ltd
1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Hawkesbury

ON K6A 1K7

Ship VIA	P.O. #	FOB	Date	Page
Fed Ex	PO34193	ORIGIN	12/14/2016	1

Quantity	Part Number	Rev	Job #
30	646.3710 Doubler	A	00015727

88/6-12-16

DAS
38
9-89

Received By: _____

Date: _____



353 Industrial Way
Fallbrook, CA 92028
Ph: 760-723-4006

Certificate Of Compliance

Date : 12/14/2016

Job No. : 00015727

Customer : Dart Aerospace Ltd

P.O. Number : PO34193

Part Number : 646.3710 A

Quantity : 30

Description : Doubler

We hereby certify that all parts and/or material supplied by us have been produced in conformance with all contractually applicable purchaser's specification as referenced in the purchase order and/or drawing(s) supplied.



RoHS 2 Compliant to Directive 2011/65/EC

DAS
38

By:

D. Van G

Date:

12-14-16